

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002264**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck panels**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed 15 % ultrasonic verifications (UT) on the partial penetration weld (PJP) after ZPMC representative verifications were completed on the deck panel DP-057-001 weld joint 7 and 10 . The QA inspector concurred with ZPMC on the overall location and sizing of the areas identified with incomplete penetration. Numerous locations with depth of penetration had less than 80 % depth of penetration. See UT report TL_6027 generated on this date.

The QA inspector had a conversation with representative Lay tao. The QA inspector informed to Mr. Lay Tao that ZPMC overlooked two indications at the PJP deck panel to U-ribs deck panel DP-001-001-001. Later, ZPMC and ABF representatives confirmed the indications on this deck panel. ABF Warren Buelher also confirmed 4 out of 7 indications (the other 3 indications ABF representative could not reported as indications with a depth of penetration less than 80 %).

The QA inspector performed UT for information to the at the junction of the bottom plate to the side plate weld joint # SEG-16A-008 (ceramic backing). The QA inspector observed indications at the back side of the plate. The QA inspector verification are still in progress.

Summary of Conversations:

As noted above.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer